Thursday, 10/08/2006 10:02:15 AM

User:

Linda Lacelle

## **Process Sheet**

**Drawing Name** 

**Part Number** 

Material **Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: PLATE

: D2002007

: NIA

: 05/09/2006

: D2002-007 REV B

Customer

Job Number

c : CU-DAR001 Dart Helicopters Services : 28137

**Estimate Number** 

: 12507

P.O. Number

: NIA

This Issue Prsht Rev.

First Issue

**Previous Run** 

: 10/08/2006

: WIA

S.O. No. : 12 14

Type : SMALL /MED FAB

: HIM

Written By Checked & Approved By

Comment

New Issue 06-08-10 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

2024-T3 .063 sheet

1.0

M2024T3S063

Comment: Qty.: 0.1111 sf(s)/Unit Total: 0.4444 sf(s)

2024-T3 .063 sheet (M2024T3S063)

Batch: M 19 050

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2002-007

Dwg Rev:\_\_\_\_\_ Prog Rev:\_\_\_

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHIN



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

12

Each

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Form: rprocess

## **Dart Aerospace Ltd**

| W/O: | W/O: WORK ORDER CHANGES |    |      |     |                                     |                          |  |  |
|------|-------------------------|----|------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP                    | Ву | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
| 1    |                         |    |      |     |                                     |                          |  |  |
|      |                         |    |      |     |                                     |                          |  |  |
|      |                         |    |      |     |                                     |                          |  |  |

Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_\_ NCR: Yes No DQA: ☐ Date: ○ Date: ○

|         |      |  |                      |                              | QA: N/C        | Closed:      | _ Date: _ |              |  |  |
|---------|------|--|----------------------|------------------------------|----------------|--------------|-----------|--------------|--|--|
| NCR:    |      | WORK ORDER NON-CONFORMANCE (NCR)   |                      |                              |                |              |           |              |  |  |
|         |      | Description of NC  |                      | Corrective Action Section B  |                | Verification | Approval  | Approval     |  |  |
| DATE    | STEP | Section A  | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section O    | Chief Eng | QC Inspector |  |  |
| a;07:14 | 20   | Mode was not made properly by the waterjet one of the hole had a chip detin it | Bosin                | Scrap and destry             | SA             |              | own.      |              |  |  |
|         |      | one of the hole had a chip detin it  | Office               |                              | 06:08:14       | 20015        | 1         | 16.0614      |  |  |
|         |      |  | -                    |                              |                |              |           |              |  |  |
|         |      |  |                      |                              |                |              |           |              |  |  |
|         | P    |  |                      |                              |                |              |           |              |  |  |
|         |      |  |                      |                              | *              |              |           |              |  |  |

NOTE: Date & initial all entries

Date:

Thursday, 10/08/2006 10:02:15 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: PLATE** 

Job Number: 28137

Part Number: D2002007

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



7.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment: PACKAGING RESOURCE #1** 

Identify and Stock

Location: 570/0



8.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



CL06108130

## **Dart Aerospace Ltd**

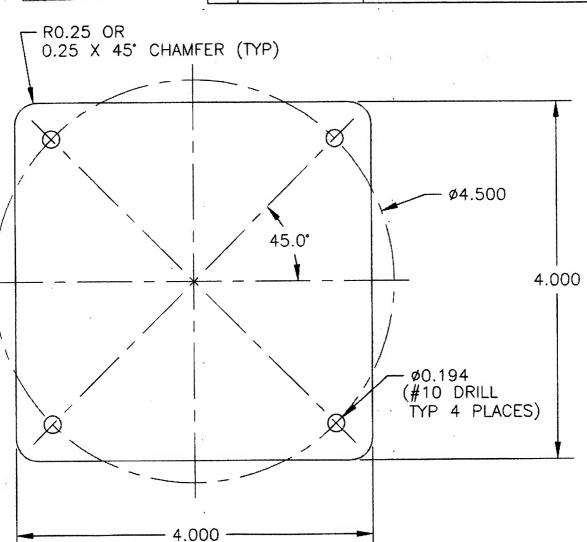
| Dail Ae | ospace | ELU               |                      |                              |                |              |           |                                     |                          |              |
|---------|--------|-------------------|----------------------|------------------------------|----------------|--------------|-----------|-------------------------------------|--------------------------|--------------|
| W/O:    |        |                   | WC                   | RK ORDER CHANG               | ES             |              |           |                                     |                          |              |
| DATE    | STEP   | PRO               | OCEDURE CHAI         | NGE                          | Ву             | Date         | Qty       | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
| 4       |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
| Part No | :      | PAR #:            | Fault Cate           | jory:                        | NCR: Yes       | No <b>DQ</b> | A:        | _ Date: _                           | <del></del>              |              |
|         |        |                   |                      |                              | QA: N/         | C Close      | d:        | _ Date: _                           |                          |              |
| NCR:    |        |                   | WORK ORDE            | R NON-CONFORMA               | NCE (NCR       | )            |           |                                     |                          |              |
|         |        | Description of NC | Corrective Action Se |                              | on B           | Verification |           | Approval                            | Approval                 |              |
| DATE    | STEP   | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date |              | Section C |                                     | Chief Eng                | QC Inspector |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
| 131     |        |                   |                      |                              |                |              |           |                                     |                          |              |
| -       |        |                   |                      | <del></del>                  |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        |                   |                      |                              |                |              |           |                                     |                          |              |
|         |        | u .               |                      |                              |                |              |           |                                     |                          |              |

NOTE: Date & initial all entries



| 1 | DESIGN | ٧                                       | DRAWN BY | A DART AEROSPACE LTD        |        |
|---|--------|---|----------|-----------------------------|--------|
| ١ | JB     | •                                       | W        | HAWKESBURY, ONTARIO, CANADA |        |
| I | CHECK  | ED                                      | APPROVED | DRAWING NO.                 | REV. B |
|   | K      | LE                                      | ##       | D2002-007 SHEET             | 1 OF 1 |
| 1 | DATE   | *************************************** |          | TITLE                       | SCALE  |
|   | 98.1   | 1.03                                    |          | PLATE                       | 1:1    |
|   | Α      |   | 90.02.27 | NEW ISSUE                   |        |
|   | В      |   | 98.11.03 | REDRAWN ON SEPARATE SHEET   | VISH   |

RELEASED



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063 THICK FINISH: ACID ETCH, ALODINÉ PER DART QSI 005 4.1

POWDER COAT BLACK CRINKLE (REF 4.3.5.3) PER DART QSI 005 4.3

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

|           |       |     | •               |  |
|-----------|-------|-----|-----------------|--|
|           | •     |     | 9.6             |  |
|           |       |     | 3>              | 4.3  |
|           |       |     | * ); =<br>Mills | The state of the s |
|           |       |     |                 | vegetier verweren  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 | , ,  |
| · ·       |       |     |                 |  |
|           |       |     | ä.              | • .<br>! 5   |
|           | · · · |     |                 |  |
| No.       |       |     |                 |  |
|           |       |     |                 |  |
| <i>p.</i> |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 |  |
|           |       |     |                 | 1  |
|           |       | (2) |                 | 1  |
| A CANADA  |       |     |                 |  |
| Enancide: | ,     |     | 32              |  |
| · ·       |       |     |                 | s:  s:   |
|           |       |     |                 | į ·  |
|           |       |     |                 | i  |

| DART AEROSPACE  | LTD    |   | Work Order:  | 28/37       |
|-----------------|--------|---|--------------|-------------|
|                 | [9]    |   |              |             |
| Description:    |        | • | Part Number: | D2002 007   |
|                 | ,      |   |              |             |
| Inspection Dwg: | , Rev: |   |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

| Drawing<br>Dimension | Tolerance    | Actual Dimension | Accept | Rejest | Method of<br>Inspection | Comments                                |
|----------------------|--------------|------------------|--------|--------|-------------------------|---|
| 4.000                | t 0.010      | 4.608            |        |        | Vern                    |   |
| 4.000                | 70.010       | 4:606            | レ      |        | yern                    |   |
| \$0,194              | +0.605/-0001 | Ø 0,194          | ~      |        | Vern                    |   |
| RO.25                | t.0.630      | RO.25            |        |        | R-G                     |   |
| 6,063                | 10.010       | 0.062            | /      |        | Vern                    |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              | ` .              | :      |        |                         |   |
|                      |              |                  |        | •      |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, |
|                      | ·            |                  |        |        |                         | <u> </u>                                |
|                      |              | 4                |        |        | ·                       |   |
|                      |              | ,                |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              | ``               |        |        |                         |   |
|                      |              |                  |        |        |                         |   |
|                      |              |                  |        |        |                         | <u>.</u>                                |
|                      |              |                  |        |        |                         | -                                       |

| Measured by: SAD | Audited by:   | Prototype Approval: |  |
|------------------|---------------|---------------------|--|
| Date: 06:08:14   | Date: Obv8-15 | . Date:             |  |

| Rev | Date  | Change    | Revised by | Approved |
|-----|-------|-----------|------------|----------|
| Α   | 31.11 | New Issue | KJ/JLM     |          |